

Work Order ID 76455

76455

Page 1

November 15 11 7:00:35 AM

Item ID: D3391-025

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Aft Tube Assembly

Stop ***NS2***

Start Date: 11/15/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/18/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

1

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: 1 & Dwg D3391 Rev: 1

scribe batch # on fwd end at 90 degree

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

111

QC8- Inspect parts - second check

0.00

111

QC

Memo

0.00

Quality Control

1 Ø
MML 11/11/15

1 Ø
MML 11/11/15

11.11.21 1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76455

November-15-11 7:00:35 AM

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 11/15/11 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/18/11 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS I HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>AP</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr	0.00 0.00	<i>SC</i>	<i>11-11-21</i>	<i>1</i>	<i>0</i>			
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>SC</i>	<i>11-11-21</i>	<i>1</i>	<i>0</i>			
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>SC</i>	<i>11-11-21</i>	<i>1</i>	<i>0</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76455

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November-15-11 7:00:35 AM

Item ID: D3391-025
Revision ID:
Item Name: Aft Tube Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 11/15/11 Start Qty: 1.00 ***1***
Required Date: 11/18/11 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

Handwritten: 11-11-22 PD →

160

0.00

160

CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

Handwritten: 11-11-22 (X)

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

Handwritten: 11-11-22

W/O: 16455		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-025 PAR #: _____ Fault Category: Machining / Landing Gear ^{stud tube} NCR: Yes No DQA: Not Date: 11/12/08
 Resolution: use AS is Disposition: use AS-en QA: N/C Closed: CK Date: 11/12/08

NCR: 11-1087		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/1/22	150	See focus some chatter marks From only 2" from the end of the tube R.C. not seen at inspection. + machine machin process chip build up	CP 11.11.23 DS/042	- Acceptable. At end of tube where there is no stress		S 11/1/23	CP 11.11.23 DS/042	S 11/1/22

NOTE: Date & initial all entries

Work Order ID 76455***76455***

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November-15-11 7:00:35 AM

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 11/15/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/18/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .								
	*****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76455

76455




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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/15/11 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/18/11 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00			11-11-28				
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							 11/11/28
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00			11-11-28				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76455

November-15-11 7:00:35 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 11/15/11 **Start Qty:** 1.00 ***1***

Required Date: 11/18/11 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

220 0.00

220

0.00

Memo

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: 117870
exp. date : 02/12.
cure time 12hrs as per QSI0015

230	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

230

Memo

Quality Control

235	Pressure Wash per QSI005 4.3	0.00
-----	------------------------------	------

235

Memo

Hand Finishing

AND REALODINE AS PER PAR09-043

Work Order ID 76455

76455

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November-15-11 7:00:35 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/15/11 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/18/11 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:30								
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 2:00								
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									
260	HandFinishing	0.00							
260									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241-291 <u>1119443</u>								
	Sikaflex expiry date: <u>12105</u>								
	3- INSTALL WEARPLATES AS PER DWG								

1X4 m-11/12/05

1118434

1 d 11/12/05

1 d 11/12/06

Work Order ID 76455***76455***

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November-15-11 7:00:35 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 11/15/11 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/18/11 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 *270* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
280 *280* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00							
290 *290* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/12/11
ME
11-12-06

Picklist Print

November-15-11 7:00:34 AM

Page 1

Work Order ID: 76455

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/15/11

Required Date: 11/18/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H 11.11.14 AS PER REV.I
 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047 Wearpad Assembly		Manufactured	No			260	Each	0.0000	1	1			
D4095-049 Wearpad Assembly		Manufactured	No			260	Each	0.0000	1	1			
D6014-090 ALUMINUM EXTRUSION		Manufactured	No			100	Each	13.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		13							
				66179		13							
D3670-4-200 SPACER		Manufactured	No			230	Each	104.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		12							
				71850		12							
				LG001		92							
				72851		92							

B76208 (v1) JL 11/12/05

B76217 (v1) JL 11/12/05

mm.L 11/11/15

Wh.
11/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-15-11 7:00:34 AM

Page 2

Work Order ID: 76455
Parent Item: D3391-025
Parent Item Name: Aft Tube Assembly

Start Date: 11/15/11
Start Qty: 1.00

Required Date: 11/18/11
Required Qty: 1.00

D2646 Manufactured No 270 Each 243.0000
Aft Cap

1 1373825 (x1) 11/12/06

Location	Loc Qty	Loc Code
FP002	226	
73294	26	
73825	200	
FP004	5	
68280	5	
FP006	5	
62678	5	
FP-4	3	
70945	1	
71070	2	
fp5	4	
71038	4	

D3672-1 Manufactured No 270 Each 688.0000
Phenolic Washer

2 11/12/06

Location	Loc Qty	Loc Code
FP-A	424	
52505	0	
66821	424	
ST074	264	
72229	264	

V2

ALS4-1032-130 Purchased No 260 Each 2,000.0000
Insert

14 1119530 (v14) 11/12/06

Location	Loc Qty	Loc Code
ST280	1984	
119084	1984	
ST281	16	
117717	2	
118237	12	
118312	2	

ALS4-1032-130

November-15-11 7:00:34 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-15-11 7:00:34 AM

Page 3

Work Order ID: 76455

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/15/11

Required Date: 11/18/11

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

270

Each

2,181.0000

8

8

Insert

Location

Loc Qty

Loc Code

ST281

2181

108696

285

110768

62

118386

858

118966

976

AN3C4A

Purchased

No

270

Each

2,151.0000

6

6

BOLT

Location

Loc Qty

Loc Code

ST350

2151

117313

2

117688

5

117872

22

118112

16

118451

2

118706

142

118838

962

119328

1000

AN3C5A

Purchased

No

270

Each

987.0000

4

4

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

980

116419

28

117343

17

117764

166

117872

2

118451

267

119127

500

AN960C10L

NAS1149C0332R

Purchased

No

270

Each

0.0000

10

10

washer

November-15-11 7:00:34 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76485
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

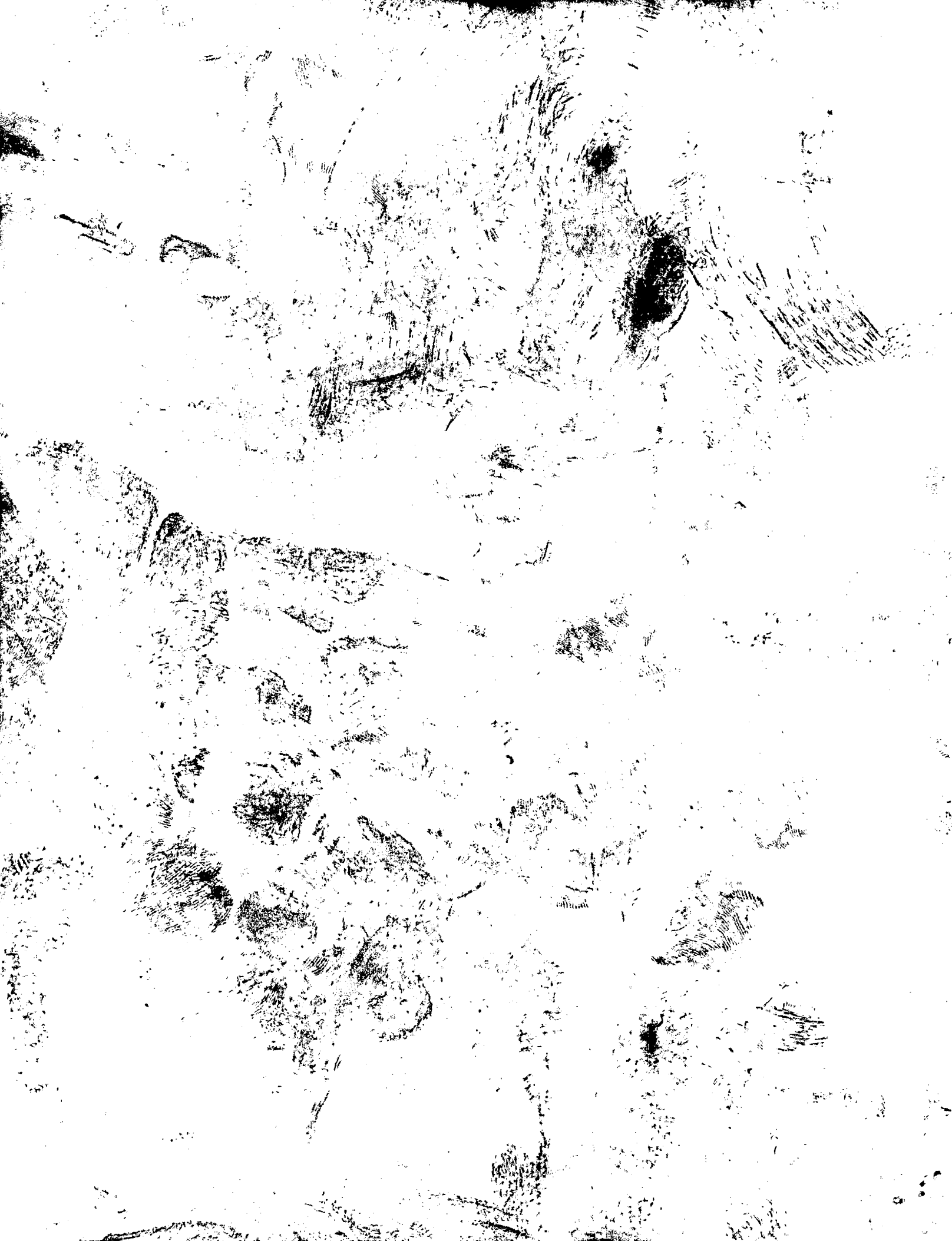
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	mm-L-02
3.500	+/-0.010	3.499	✓		vern	OWC-08
88.93	+/-0.030	88.936	✓		tape	mm-L-02
Ø3.200	+/-0.010	3.202	✓		vern	OWC-08
88.93	+/-0.030	88.936	✓		tape	mm-L-02
Ø3.750	+/-0.010	3.750	✓		vern	CWC-08
30° x 160° chamfer	+/-0.010	30° x 160	✓			

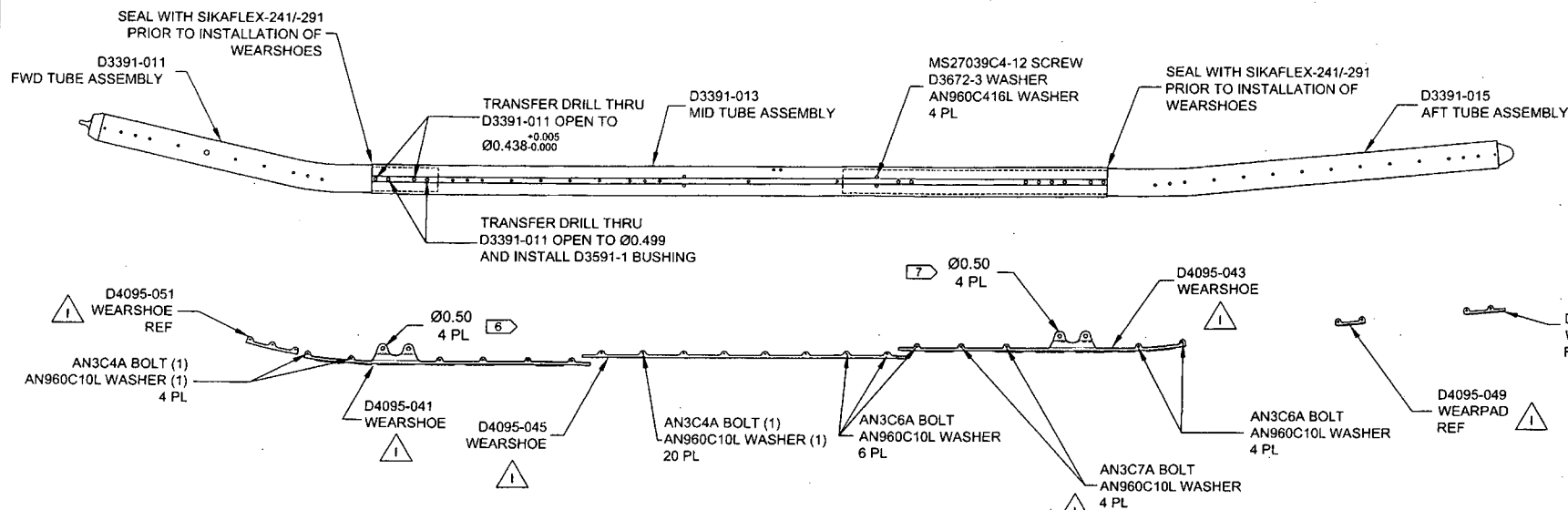
Measured by: MML	Date: 11/11/15
Audited by: RCB	Date: 11-11-25

HAAS Section						
1.526	+0.000/-0.030	1.505	✓		Vern	BC-06
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.305	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.484	✓			

Measured by: BC	Date: 11/11/15
Audited by: RCB	Date: 11-11-25

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	








D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

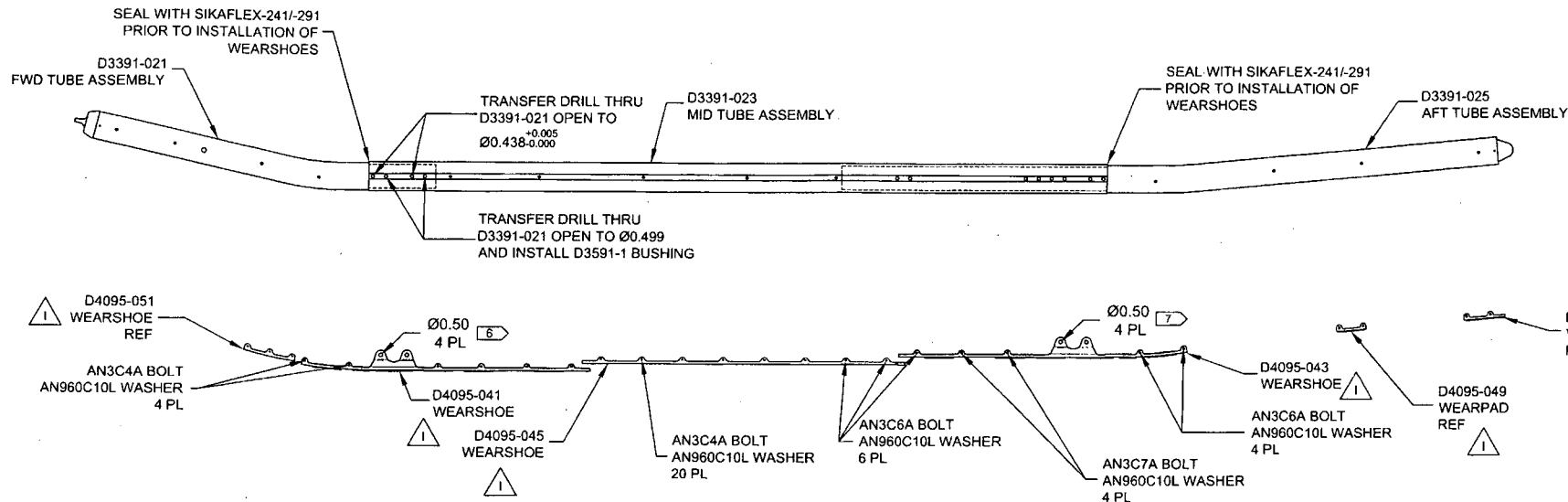
QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3581-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 1 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NT
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

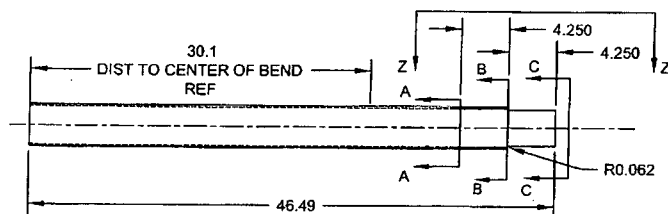
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

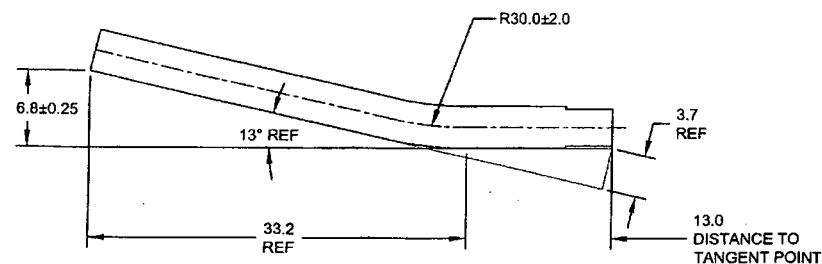
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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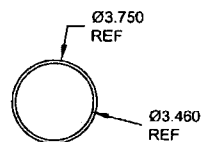
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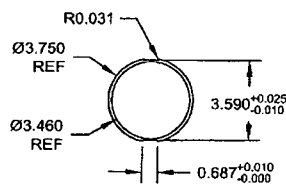
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



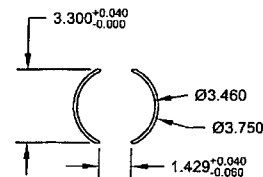
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



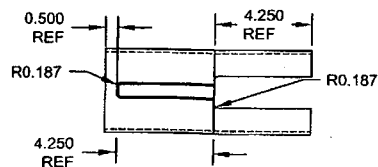
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



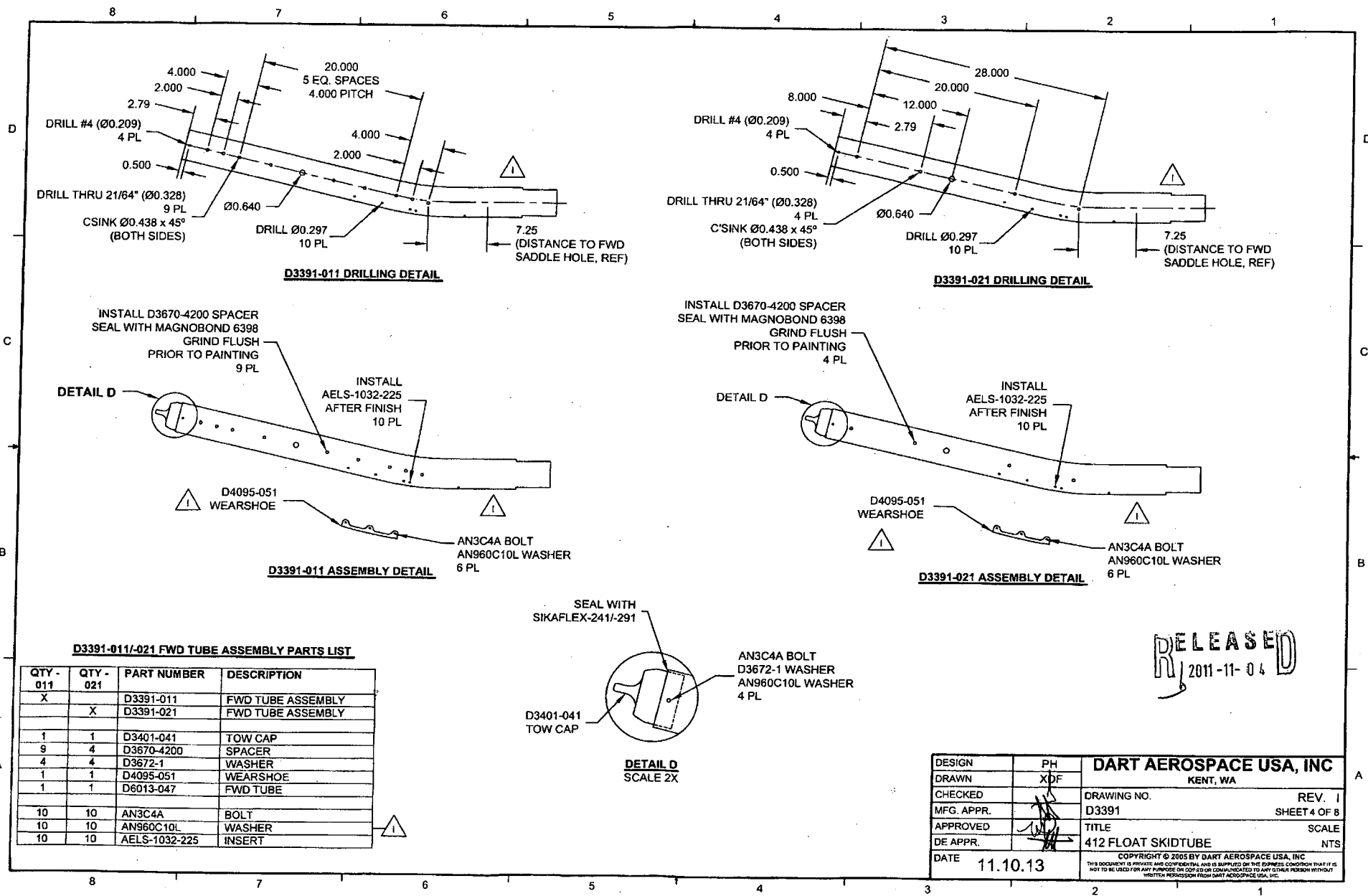
SECTION C-C
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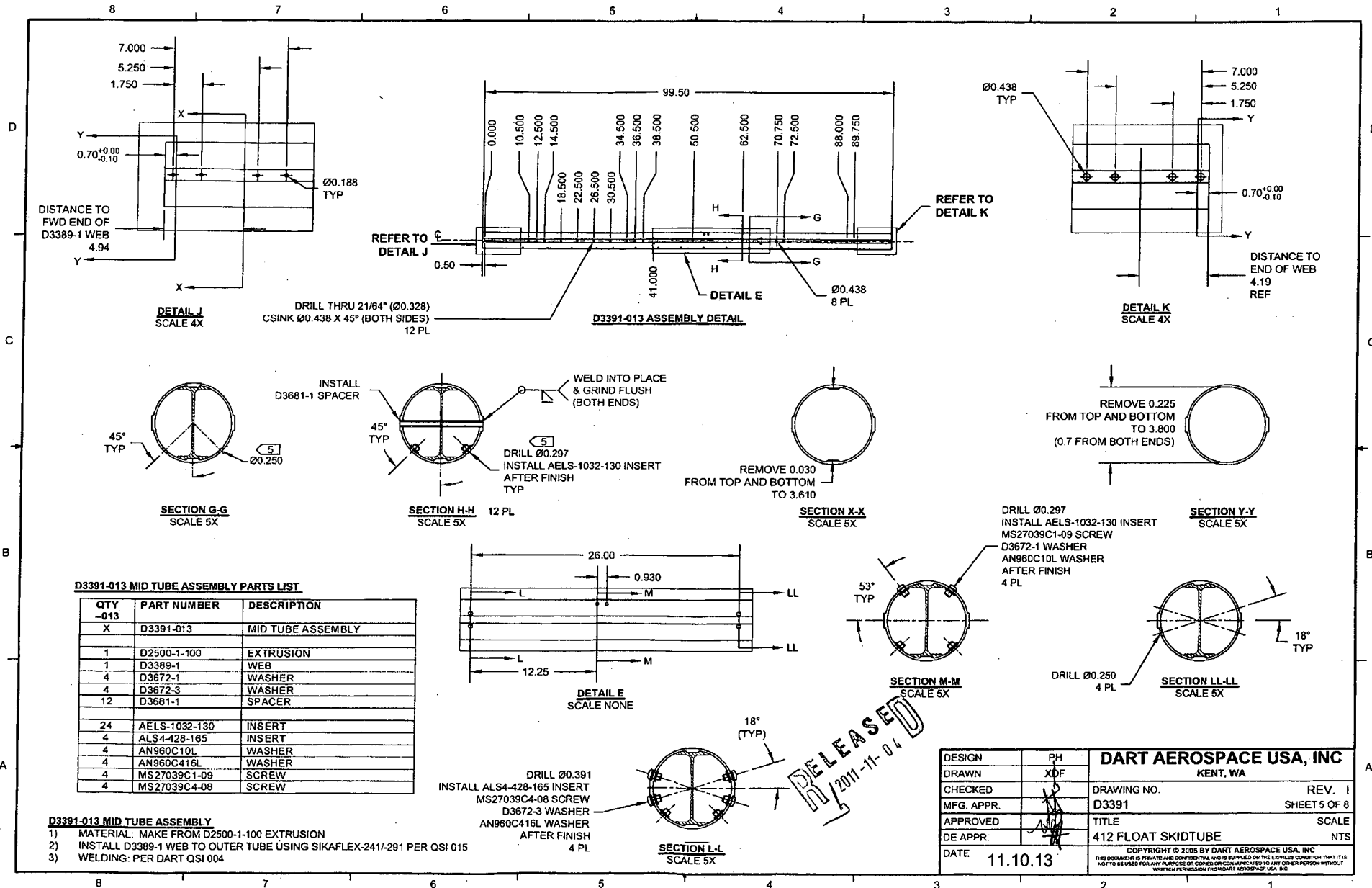


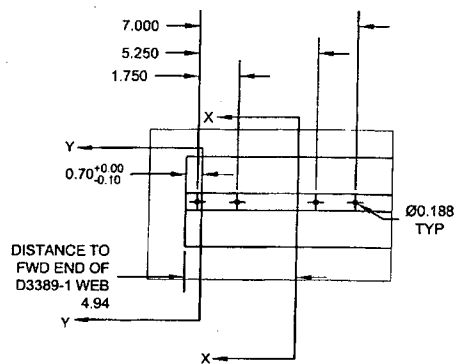
VIEW Z-Z
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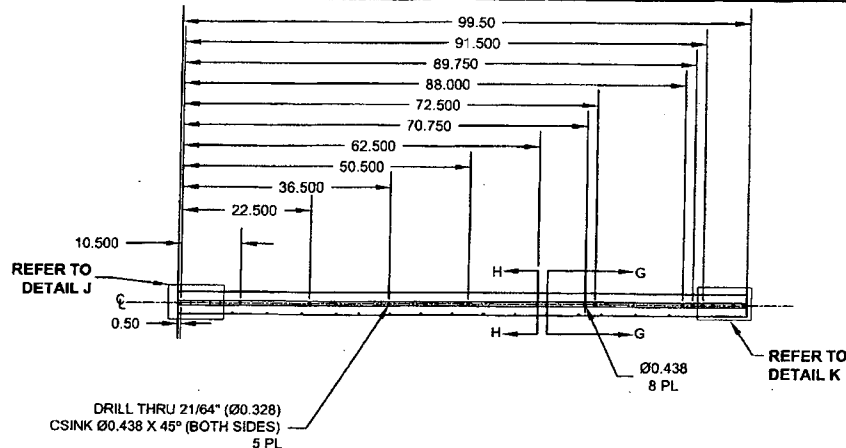
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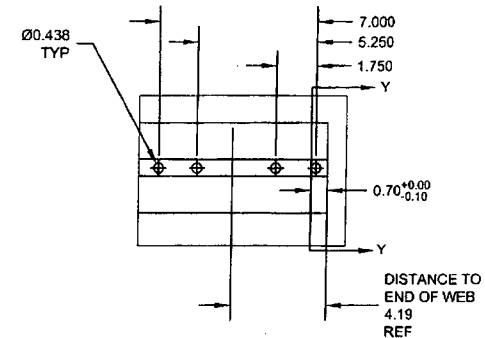




DETAIL J
SCALE 4X



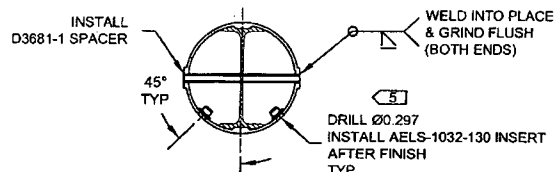
D3391-023 ASSEMBLY DETAIL



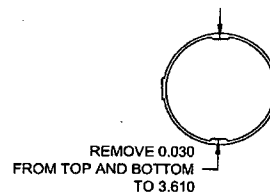
DETAIL K
SCALE 4X



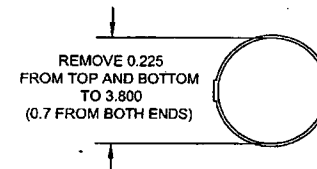
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

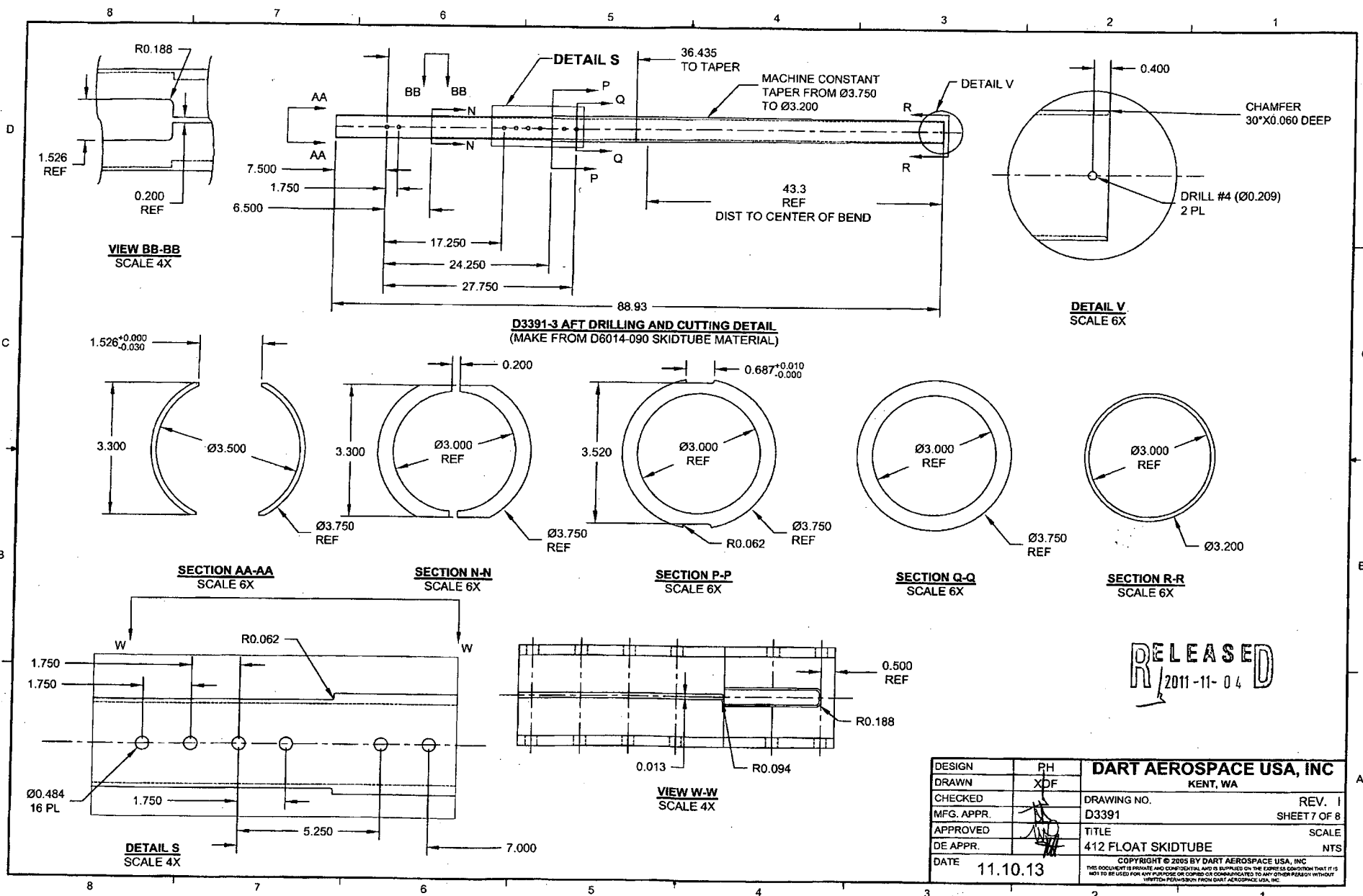
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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